

REPORT

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50X1-HUM

COUNTRY USSR (Leningrad Oblast)

SUBJECT Leningrad Automatic Machine Tool Factory

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1. The Leningrad Automatic Machine Tool Factory (Leningradskiy Avtomaticheskiy Zavod Avtomaticheskoy Mashinostroyeniya) is located in the Zhukovskiy (ex-Primorskiy) district of Leningrad. The factory comes under the Chief Directorate of Machine Tool Industry of the Ministry of Machine Tool Construction of the USSR.
2. The factory was founded shortly before the war and produced automatic machine tools. It was evacuated during the war, but the buildings were only slightly damaged by bombs. After the war, the factory returned to Leningrad and again took up the production of automatic machine tools. The pre-war level of output was reached in 1946.
3. The chief products of the factory are longbed automatic lathes (tchekany avtomat prodolno-klasovogo tocheniya) for use by the automobile industry, for instrument construction, and for the electrical industry. The machine tools produced by the factory include the following:
 - a. Single-spindle longbed automatic lathe, type "110", for machining rods of up to 7 mm diameter. The maximum length of rod which can be machined is 4 meters. The overall dimensions of the lathe are approximately 1,300 x 650 x 1,000 mm. The lathe is driven by an electric motor of 2.2 KW with a speed of 1,400 rpm. The spindle speed limits are 1,800 - 10,000 rpm. The output of the lathe depends on the nature of the work and the material used. For instance, comparatively simple articles of brass can be turned out by the machine at the rate of 10 to 25 per minute, while articles of high speed (avtomatnaya) steel are produced at the rate of two to six per minute.
 - b. Single-spindle longbed automatic lathe, type "112", which is very similar to the type "110." It is designed for machining rods up to 12 mm in diameter and 3.5 meters in length. The overall dimensions are approximately 1,500 x 600 x 1,100. The lathe is driven by an electric motor of 2.2 KW. The spindle speed limits are 800 - 7,500 rpm.

50X1-HUM

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- 2 -

50X1-HUM

- c. Single-spindle longbed automatic lathe, type "111 p". Electric motor rating 2.8 KW. Overall dimensions approximately 1,500 x 650 x 1,000 mm. It is designed for machining rods up to 10 mm in diameter and 3.5 meters in length.
 - d. Automatic longbed lathe, type "1117" for machining rods up to 18 mm in diameter. Equipped with a 2.5 KW "AD" electric motor with a speed of 1,500 rpm. It has an auxiliary 0.8 KW motor with a speed of 900 rpm. The first small series production, consisting of 35 of these lathes, was not completed until April 1949. A new model of this lathe, which differs in a few respects from the original, has now been put into large series production.
 - e. Single-spindle automatic shaping machine (odno-shpindelny tokarnofazonnny otreznoi avtomat), type "1106", which machines articles from a coil (bunt). Articles are produced from coiled rolled metal. The overall dimensions of the machine are 1,800 x 700 x 1,450 mm. Motor rating is 2.2 KW. Articles up to 8 mm in diameter can be machined. The spindle speed varies from 1,200 to 3,500 rpm.
 - f. Two types of milling and slotting machines (shlitse-frezernyy avtomat) for milling grooved rollers and cutting cylindrical gears with straight teeth.
 - g. Longbed lathes, type "1A-1".
 - h. Automatic machine for making rollers for agricultural machinery bearings. This machine produces 10-12 rollers per minute.
 - i. Semi-automatic machines for milling helical drills. Up to the present, these machines have been produced in two sizes, six machines of each size. A third size is nearly ready for production. These machines will be put into small series production.
 - j. Two types of automatic machines for producing pins and bolts. Production about 50 pins and bolts per minute.
4. Actual output in 1947 was about 350 automatic machines and in 1948 about 500 automatic machines.
5. In May 1949, the factory employees numbered about 1,600 and the staff included the following:
- | | |
|-----------------|---|
| Director: | P. D. Khizhnyak |
| Chief Designer: | A. A. Aleksanyants |
| Chief Engineer: | Zakharin |
| Designers: | I. N. Kostygov, G. Yu. Krasov, A. E. Zakharov (Head of Experimental Shop) |
6. Castings for large machine parts are obtained from the Leninskii Iron Foundry at Leningrad. A number of articles for the engineering shops are obtained from the Leningrad Machine Tool Accessories Factory (Leningradski Stankostroitelny Zavod Stankoprindlezhnostei).
7. General State of Factory:
- The factory output continues to increase as a result of improvements in organization and mechanization. The internal transport of the factory has been largely mechanized, the organization of the foundry improved, and new methods of casting introduced. Considerable improvements have taken place in the engineering shops.

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